2

Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3914-041
Job Sheet 201277

Part No: D3914-041 **Job Qty:** 1 pcs
Part Name: Long Basket Lid Assembly (350)

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 9/30/19 **Job Tracking No:**
Due Date: 11/11/19 **Created By:** Marie Lajeunesse
Type: Stock **Description:**

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Basket - 1	1 pcs		11/11/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		MAL
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs		11/11/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		DAS 24 9-89
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs		11/11/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS 24 9-89
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

DART AEROSPACE

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Container No: S230199

Part: D3914-041
Job No: 201277
Serial No/Batch: S230199
Revision: A/D
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/08/19

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130	**Powdercoat - 4 Black Sand - B4B** M156410. START; O.T: 320°F Finish:	1 pcs	11/11/19	0.00 0.40	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BE 19-12-3
					Powdercoat - 4 - B4B	
135	**QC 3**	1 pcs	11/11/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	BE 19-12-3
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
140	**Handfinish - 3-1- WingWalk- B4B**	1 pcs	11/11/19	0.00 0.80	Handfinish - 3 - 1 - B4B	BE 19-12-04
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
150	**QC 3**	1 pcs	11/11/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	BEB 19-12-04
					QC 3 - 68	

DAS 15 9-89

DAS 59 9-89

					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
160	**Packaging 3-1 - Stock - B4B**	1 pcs	11/11/19	0.00 0.00	Packaging 3 - 1 - B4B	JL 14-12-Od
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 -	

					B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 **QC 21 - SA**	1 pcs	11/11/19	0.00	0.00	QC 21 - SA - 21 DAS 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	DEC 04 2019

Part Op Descriptions: **100** - (Weld per dwg A/R S.S. rod Batch:M139015 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***
135 - QC3- Inspect Part Finish
140 - Wing Walk as per dwg QSI005 4.4 Batch_____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***
150 - QC3- Inspect Part Finish
160 - Identify as per dwg & Stock Location:_____
170 - QC21- Final Inspection - Work Order Release

MU# 012777

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S214321
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S222855
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S221681
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	S221960
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	2x S215570/7 x S215615
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	~~S172801~~ S229696
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S172801
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	S225517

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	131	0
	D3914-1	2	6	0
	D3914-7	2	16	0
	D4016-3	3	36	0
	D4018-5	9	53	0
	D4020-5	1	2	0
	D4021-3	1	18	0
	D4035-043	2	14	0

Part Specifications

Specifications could not be found.

Plex 9/30/19 11:44 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong
☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance
☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing
☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing
☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread
☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up

Other/Details: